

Shp Thurs 13/10

Work Order ID 74859

October-12-11 11:59:47 AM

74859

~~PRELIMINARY ISSUE~~

Page 1

Item ID: D4404-9
Revision ID: PRELIM
Item Name: Cushion, Lower Side

Accept

N900040100

Setup Start *NS1*

Stop *NS2*


Start Date: 10/12/11 Start Qty: 1.00 *1*

Required Date: 10/12/11 Req'd Qty: 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:  Date:
QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4404	PB3 B 10.10.14
-------	----------------

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

Cut as per dwg D4404

Prog. rev: PB3

Dwg rev: PB3

0.00

11-10-12

①

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

11-10-12

120

QC8- Inspect parts - second check

0.00

120

QC

Quality Control

Memo

0.00

ml 11.10.13 ①

As per PB3 Dwg

Work Order ID 74859

October-12-11 11:59:47 AM

74859

Page 2

Item ID: D4404-9
Revision ID: PRELIM
Item Name: Cushion, Lower Side

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 10/12/11 Start Qty: 1.00 ***1***

Required Date: 10/12/11 Req'd Qty: 1.00 ***1***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date:

QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

10/10/12

11/12/15

*C of C issued
CK 10/11/17*

POSITIVE RECALL
EFFECTIVE 11/10/12 AUTH h
RELEASED h DATE 11.10.14
OKAY TO SHIP TO CUSTOMER.
* COPY OF DSI 9577 TO
FOLLOW EARLY NEXT WEEK
W/RELEASE OF PAPERWORK.

Picklist Print

October-12-11 11:59:47 AM

Page 1

Work Order ID: 74859

Parent Item: D4404-9

Parent Item Name: Cushion, Lower Side

Start Date: 10/12/11

Required Date: 10/12/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev. A 11.10.12 new Issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	481.8500	3.4	3.5789474			
NEOPRENE SHEET 0.063													

Location

Loc Qty

Loc Code

MAT052

481.85

117295

55.68

118026

127.87

118663

4.3

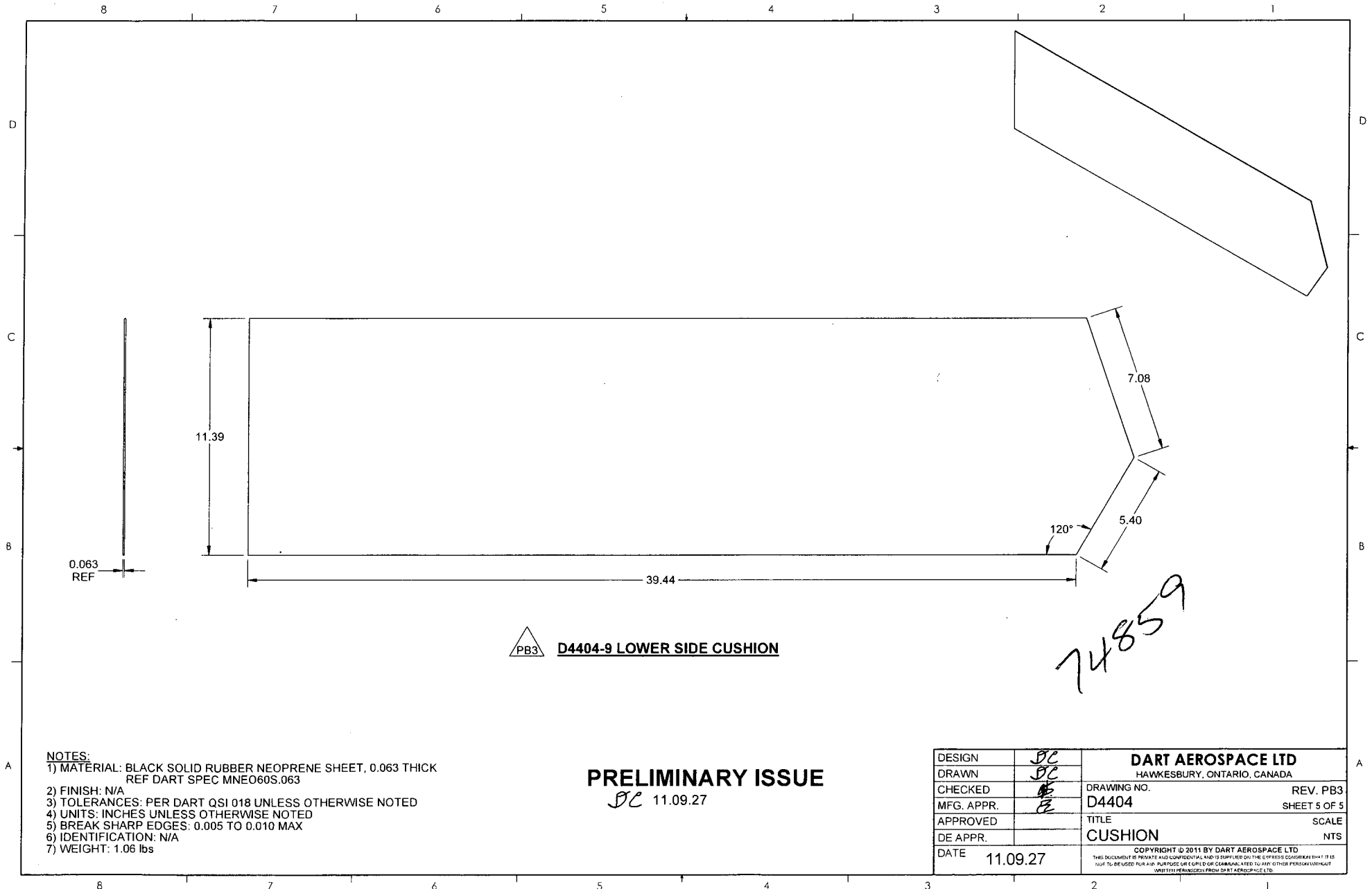
119130

294

1311-10-12

①

119130



D4404-9 LOWER SIDE CUSHION

NOTES:

- 1) MATERIAL: BLACK SOLID RUBBER NEOPRENE SHEET, 0.063 THICK
REF DART SPEC MNE060S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.06 lbs

PRELIMINARY ISSUE

DL 11.09.27

DESIGN	<i>DL</i>	DART AEROSPACE LTD	
DRAWN	<i>DL</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>DL</i>	DRAWING NO.	REV. PB3
MFG. APPR.	<i>DL</i>	D4404	SHEET 5 OF 5
APPROVED	<i>DL</i>	TITLE	SCALE
DE APPR.		CUSHION	NTS
DATE	11.09.27	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Marc Bellavance

From: David Shepherd <dshepherd@dartaero.com>
Sent: October 3, 2011 10:43 AM
To: 'Daniel Campbell'
Cc: 'Marc Bellavance'; 'Harvey Siemens'; Mike Petsche
Subject: RE: D350-794 Aux Tank Cushion

Follow Up Flag: Follow up
Flag Status: Completed

Dan,

Marc and I discussed this this morning and we believe it is best to create a D4404-7 cushion specifically for the back side of the old tanks. We will then create a DSI kit that allows customers with existing tanks to add the cushions to the bottom, back, and fwd faces.

If you can update the D4404 dwg, then Marc has agreed to create the necessary DSI for this.

David

From: Daniel Campbell [<mailto:dcampbell@dartaero.com>]
Sent: September-28-11 8:48 AM
To: David Shepherd
Cc: Marc Bellavance; Harvey Siemens
Subject: D350-794 Aux Tank Cushion

Hi David,

There's a customer looking for a foam cushion to go on the inboard vertical side of the tank.

I have designed a cushion for the newer/updated tank, however, the customer has the older version of the tank.

Marc, Harvey, and I have been in discussion about this and Marc has drawn up the attached diagram, showing the customer how he can cut and trim the one piece cushion to fit the tank.

I've also included D4404-PB1 drawing which shows the -3 cushion before it is cut/trimmed.

How should we go about getting this off to the customer?

Should I/we:

1. Include this in the IIN/ICA?
2. Create a DSI for it?
3. Just manufacture it and send it along with Marc's diagram to the customer?
4. Other option?

Marc – maybe you can find out how quickly the customer is looking for a fix?

Thanks,

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325

F: 403-717-1288

E: dcampbell@dartaero.com

W: www.dartaero.com

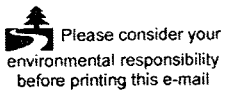
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

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Marc Bellavance

From: Marc Bellavance <mbellavance@dartaero.com>
Sent: September 28, 2011 9:41 AM
To: 'Harvey Siemens'; 'Daniel Campbell'
Subject: RE: D350-794

No, it will unfortunately make it even shorter.



Marc Bellavance
Technical/Shop Support
Tel: 613-632-5200 Ext. 243
Cel: 613-676-0992
Fax: 613-632-9311

Product Documentation: Verify Revision Status/Download [HERE!](#)

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From: Harvey Siemens [mailto:hsiemens@dartaero.com]
Sent: September 28, 2011 9:30 AM
To: 'Marc Bellavance'; 'Daniel Campbell'
Subject: RE: D350-794

What about if you fold the cushion into the bend? I'll bet you can make it fit then? ☺ ☺

Regards,

Harvey Siemens

Mechanical Designer
DART Aerospace Ltd.

P: 403-717-0328
F: 403-717-1288
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From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: September-28-11 7:18 AM
To: 'Harvey Siemens'; 'Daniel Campbell'
Subject: RE: D350-794

It makes sense, and I'm really in favour for having only one P/N for that side cushion, but based on how D4404-3 fits on D4055-041, see attached, I think we need another P/N...



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From: Harvey Siemens [mailto:hsiemens@dartaero.com]
Sent: September 28, 2011 9:00 AM
To: 'Marc Bellavance'; 'Daniel Campbell'
Subject: RE: D350-794

Marc

I think as long as we add a note to "trim to fit" one side would be ok. If you really think that we need to have 2 different ones we could do that too.

Regards,

Harvey Siemens

Mechanical Designer
DART Aerospace Ltd.

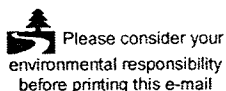
P: 403-717-0328
F: 403-717-1288
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W: www.dartaero.com
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From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: September-28-11 6:24 AM
To: 'Daniel Campbell'
Cc: 'Harvey Siemens'
Subject: RE: D350-794

Thanks for this Dan/Harvey.

My only concern is that this customer has the old tank and other customers might run into the same problem. Would it be too much trouble to add a D4404-7 Side Cushion that would fit the current tank? D4404-5 would be OK for both tank design.



Marc Bellavance
Technical/Shop Support
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From: Daniel Campbell [mailto:dcampbell@dartaero.com]
Sent: September 27, 2011 4:44 PM
To: 'Marc Bellavance'
Cc: Harvey Siemens
Subject: RE: D350-794

Hi Marc,

I talked to Harvey and he thought it would be okay to go ahead with a prelim dwg and manufacture parts from that. (Perhaps it needs a positive recall? – I'm not sure of the exact terms).

Anyway, I have created D4404-PB1 which in the Prelim folder, along with the dxfs. Harvey has checked this dwg.

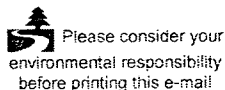
You can ahead and have these parts cut and test fit on one the tanks you've got there. The D4404-3/-5 will probably be a little bit shorter since the updated tank will be slightly shorter to accommodate the FAA required sumps.

If the fit of these parts is ok, then they probably can go out to the customer.

Cheers,
Dan

From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: September-27-11 11:44 AM
To: 'Daniel Campbell'
Subject: RE: D350-794

Yes, only a released drawing for the foam cushions. Unless David is OK if we supply the part under positive recall. In that case, a prelim issued drawing would work. Perhaps we can start manufacturing with a prelim issued drawing? This is mainly to satisfy this one customer.



Marc Bellavance
Technical/Shop Support
Tel: 613-632-5200 Ext. 243
Cel: 613-676-0992
Fax: 613-632-9311

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From: Daniel Campbell [mailto:dcampbell@dartaero.com]
Sent: September 27, 2011 1:15 PM
To: 'Marc Bellavance'
Subject: RE: D350-794

Hi Marc,

I can have the drawing done for the foam cushions fairly quickly – David doesn't get back to the office until Friday. So, I think the earliest it would be approved would be then.

However, I'm doing a whole bunch of updates & changes for the aux tank – some driven by CARs and PARs and others by the requirements to get it certified for the FAA. I have about 10 drawings to update/re-do and the IIN & ICA will probably need updating, too. Then, it needs to get approved by the FAA.

Are you looking for just a released drawing for the foam cushions?

Thanks,
Dan


From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: September-27-11 7:06 AM
To: 'Daniel Campbell'
Subject: RE: D350-794

No problem Dan.

It would make sense to cover the entire area of the inboard face, aesthetically better than to have a few strips installed here and there. When do you think you can have the drawing ready for approval? I'm asking because I just received an email (attached) from a customer in need of that.

Thanks,



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-----Original Message-----

From: Daniel Campbell [mailto:dcampbell@dartaero.com]
Sent: September 26, 2011 4:55 PM
To: 'Marc Bellavance'
Subject: RE: D350-794

Hi Marc,

Thank you very much. This is exactly what I was looking for.

I had thought that the inboard face cushioning should be the entire area of the inboard face.

Should it have a different/smaller shape?

Thanks,
Dan

-----Original Message-----

From: Marc Bellavance [mailto:mbellavance@dartaero.com]

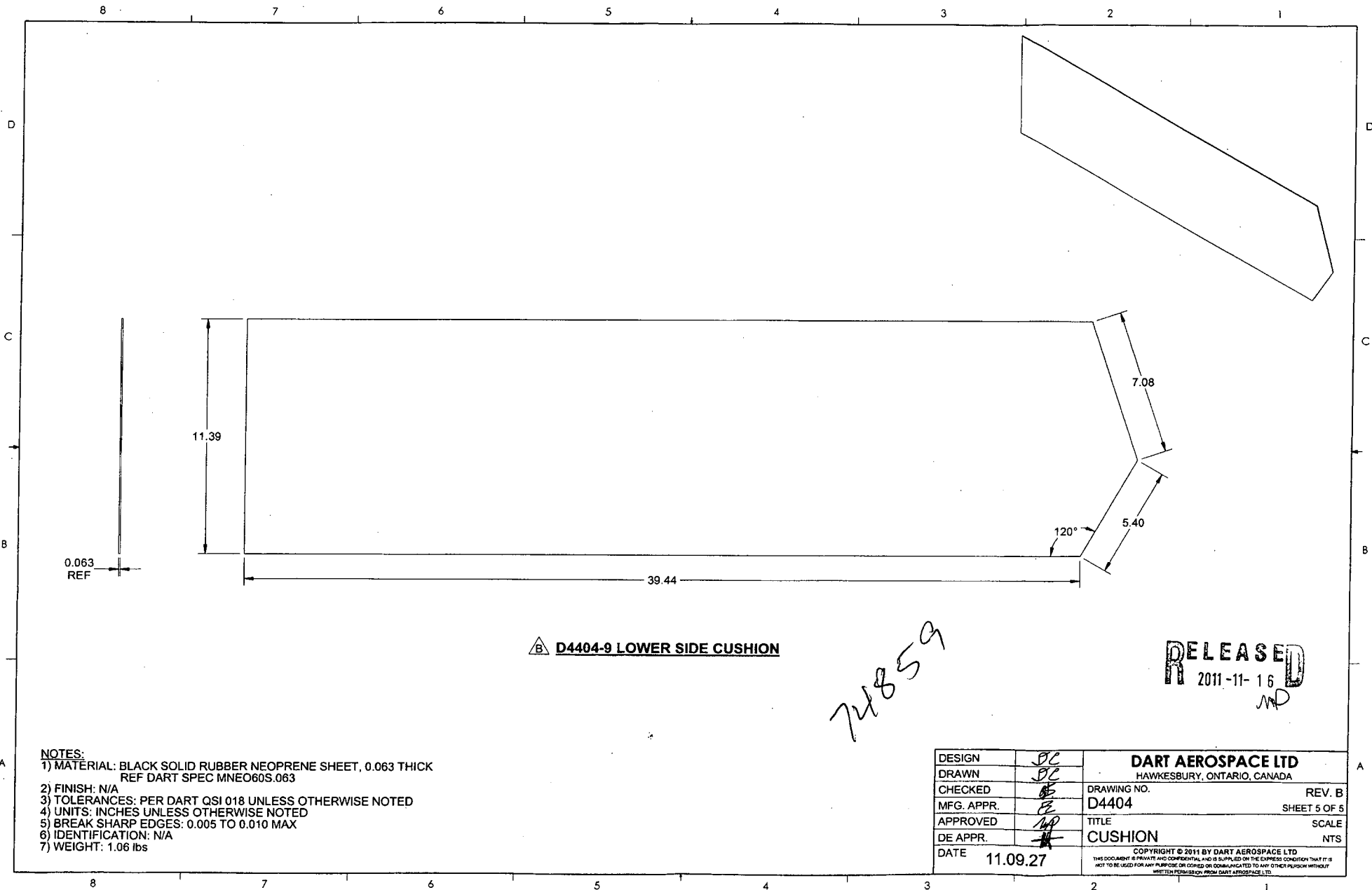
Sent: September-26-11 2:56 PM

To: Daniel Campbell

Subject: D350-794

Here you go Dan. Let me know if you need details about the inboard face cushioning.

Marc



B D4404-9 LOWER SIDE CUSHION

74859

RELEASED
2011-11-16
MD

NOTES:

- 1) MATERIAL: BLACK SOLID RUBBER NEOPRENE SHEET, 0.063 THICK
REF DART SPEC MNEO60S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.06 lbs

DESIGN	DC	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DB	DRAWING NO.	REV. B
MFG. APPR.	FE	D4404	SHEET 5 OF 5
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	CUSHION	NTS
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